

Work Order ID 80647***80647***

Page 1

February-24-12 3:24:50 PM

Item ID: D4436-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Outboard Bracket Assembly

Start Date: 24/02/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 15/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: M.C.J.Date: 12/02/27 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4436

A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut D4436-1 as per Dwg

Dwg Rev: 1Prog Rev: 1

2-Deburr if necessary

B12-38

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B12-38

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00		5/12/03/08		(40)			
Quality Control									

130	Bend as per dwg	0.00							
130									
Brake NC	Memo	0.00		5/12/03/09		(10)			
Brake NC									

140		0.00							
140									
Small Fab	Memo	0.00							
Small Fab	C"SINK AS PER DWG								

5/12/03/09 (10)

W/O:		WORK ORDER CHANGES					
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 QC5- Inspect part completeness to step on W/O 0.00

150

QC

Memo

Quality Control

160 Chemical Conversion Coat per QSI005 4.1 0.00

160

HandFinish

Memo

Hand Finishing

170 QC3- Inspect Part Finish 0.00

170

QC

Memo

Quality Control

Scrap

(40)

10X of M/L 12/23/12

10 BR 12-3-12

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

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10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

0.00

180

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg, do not install rubber seal.

Handwritten: 2/25/12 / 03/13 (10)

185

QC5- Inspect part completeness to step on W/O

0.00

185

QC

Memo

0.00

Quality Control

Handwritten: 5/26/13

Handwritten: (X10)

190

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

190

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Handwritten: 7h45
320°F
8h15

Handwritten: M125128

Handwritten: 10 & 12/03/20

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200 QC3- Inspect Part Finish 0.00

200

QC

Memo

0.00

Quality Control

10 X 8 M / 12/03/20

202 0.00

202

Small Fab

Memo

0.00

Small Fab

Install rubber seal as per dwg

3M 1300 batch: M 120954

SP 12/03/27

10

205 QC5- Inspect part completeness to step on W/O 0.00

205

QC

Memo

0.00

Quality Control

8/2/03/28

10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 24/02/2012 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 15/03/2012 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Operation Description

Set Up/ Run Hours

Tool ID	Tool #
---------	--------

Plan Code

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

210

Identify as per dwg & Stock Location GA

0.00

210

Packaging

Memo

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

Sp 12/03/28

10

MLJ 12/03/28

MLJ 12/03/28
10

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 80647

80647

Parent Item: D4436-043

D4436-043

Parent Item Name: Aft Outboard Bracket Assembly

Start Date: 24/02/2012

Required Date: 15/03/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP revA 11.10.06 new issue EC verified by:DD
12.01.24 PER DWG REV.A DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.040

Purchased

No

100

sf

294.9670

1.59

16.73684

M6061T6S 040

6061-T6 .040 Sheet

**

B12-3-8

Location

Loc Qty

Loc Code

MAT021

294.967

117653

27.91

120154

90

120218

177.057

120154

(14)

MS20426AD3-2

Purchased

No

180

Each

18,319.00

4

40

MS20426AD3-2

Rivet

**

B12/03/13

Location

Loc Qty

Loc Code

Mezz

18319

1173

8919

13276

9400

1119109 (40)

MS21075L08

Purchased

No

180

Each

364.0000

2

20

MS21075L 08

ANCHOR NUT

**

B12/03/13

Location

Loc Qty

Loc Code

ST303

302

111578

2

120560

300

ST304

62

120121

62

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 80647

80647

Parent Item: D4436-043

D4436-043

Parent Item Name: Aft Outboard Bracket Assembly

Start Date: 24/02/2012

Required Date: 15/03/2012

Start Qty: 10.00

Required Qty: 10.00

D4441-1

Manufactured No

202 f

24.7270 1.408 14.08

D4441-1

**

SR 12/03/27

Rubber Seal

Location

Loc Qty

Loc Code

prelim

24.727

74760

24.727

cut qty 1 to 16.00"

D79385

14.88

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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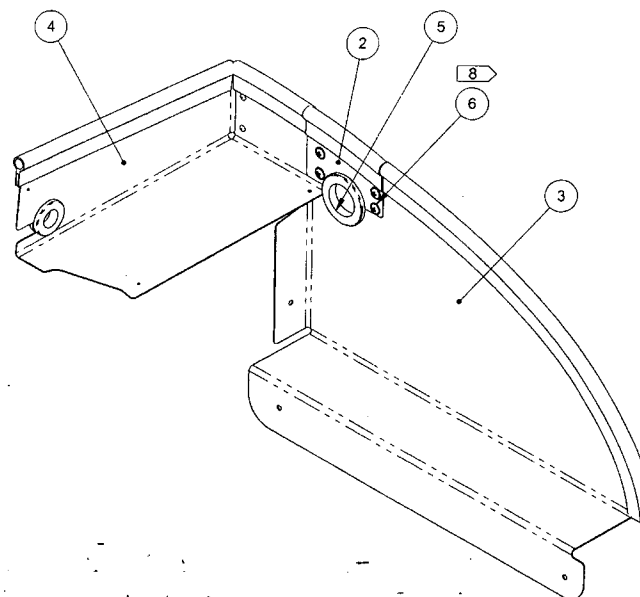
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4436-041	AFT BRACKET ASSEMBLY
2	1	D4435-043	BRACKET ASSEMBLY
3	1	D4436-043	AFT OUTBOARD BRACKET ASSEMBLY
4	1	D4436-045	AFT INBOARD BRACKET ASSEMBLY
5	1	D4440-1	GROMMET
6	4	AN525-832R6	SCREW



D4436-041 AFT BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.31 lbs
- 8) TORQUE SCREW TO 12-15 (in-lb)

A		NEW ISSUE		RF	12.01.17
REV.	DESCRIPTION			BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	RF				
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A		
MFG. APPR.	<i>[Signature]</i>	D4436	SHEET 1 OF 7		
APPROVED	<i>[Signature]</i>	TITLE	SCALE		
DE APPR.	<i>[Signature]</i>	COVER ASSEMBLY	NTS		
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UNCLASSIFIED
 SUBMIT
 WIT
 NO. 806474.05
 12/02/27

RELEASED
 12 2012 01 23
[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

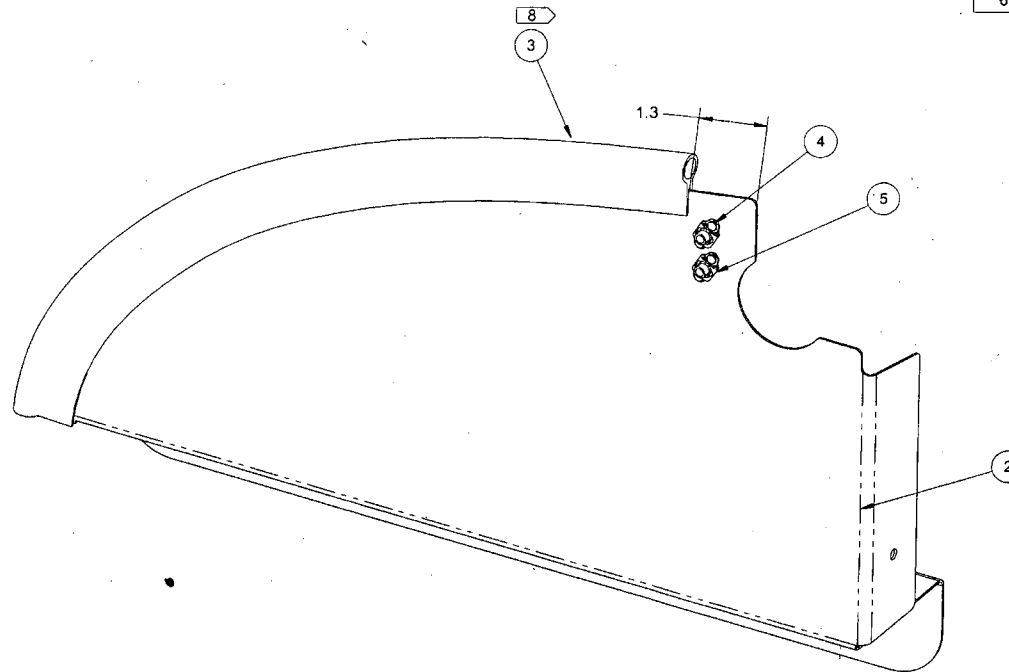
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY .043	PART NUMBER	DESCRIPTION
1	X	D4436-043	AFT OUTBOARD BRACKET ASSEMBLY
2	1	D4436-1	BRACKET
3	1	D4441-1-160	RUBBER SEAL
4	4	MS20426AD3-2	RIVET
5	2	MS21075L08	NUT PLATE
6	A/R	3M 1300/1300L	ADHESIVE



D4436-043 AFT OUTBOARD BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANTEX" (4.3.5.7) PER DART QSI 005 4.3
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL.
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4436	REV. A
MFG. APPR.	RF	SHEET 2 OF 7	
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80647

2012-01-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

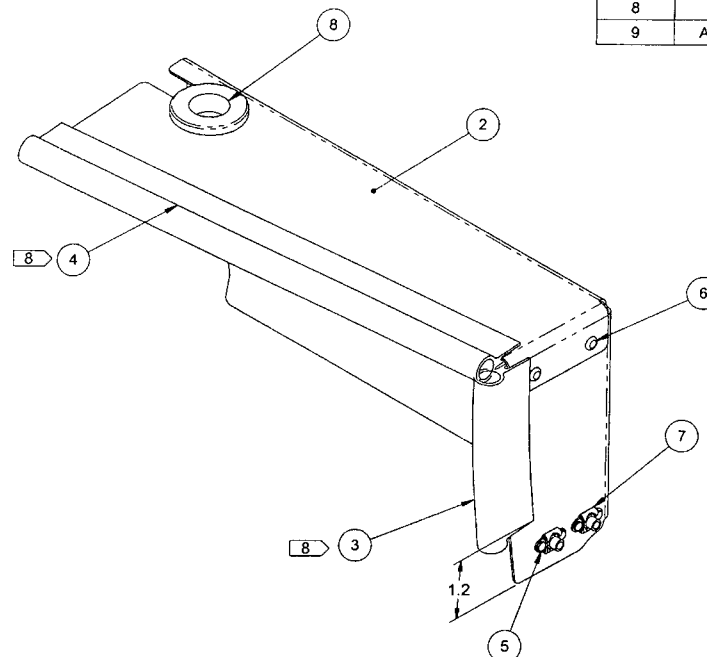
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NOTE: Date & initial all entries

ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D4436-045	AFT INBOARD BRACKET ASSEMBLY
2	1	D4436-3	BRACKET
3	1	D4441-1-038	RUBBER SEAL
4	1	D4441-1-100	RUBBER SEAL
5	4	MS20426AD3-2	RIVET
6	2	MS20470AD4-3	RIVET
7	2	MS21075L08	NUT PLATE
8	1	MS35489-19	GROMMET
9	A/R	3M 1300/1300L	ADHESIVE



D4436-045 AFT INBOARD BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE,
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL.
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4436	REV. A
MFG. APPR.	RF	TITLE COVER ASSEMBLY	SHEET 3 OF 7
APPROVED	RF	SCALE	NTS
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DATE	12.01.17		

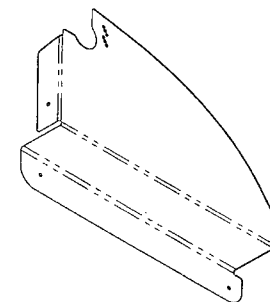
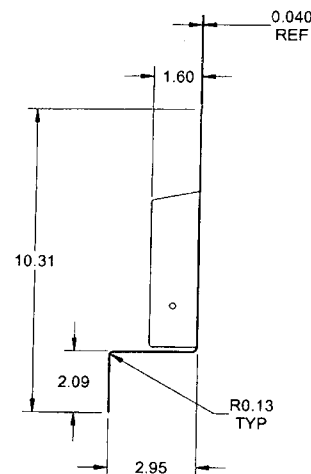
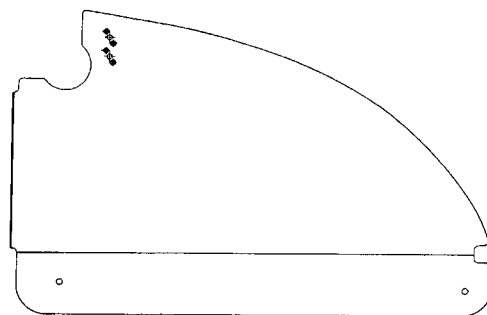
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



80647

D4436-1 BRACKET

RELEASE
11 2012-01-23

NOTES:

- 1) MATERIAL: MAKE FROM D4436-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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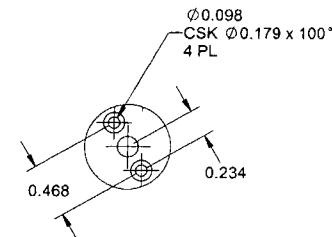
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

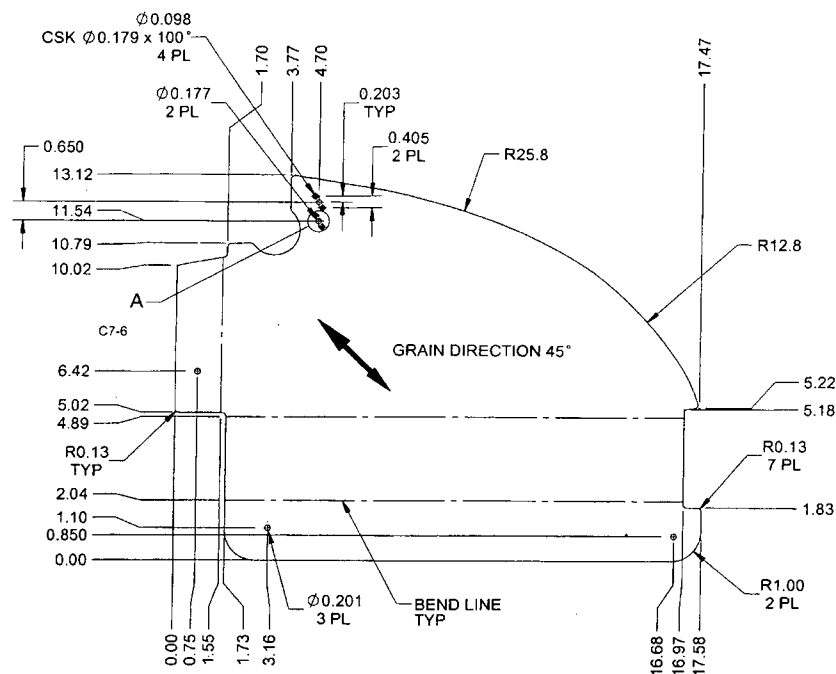
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL A C9-6
SCALE 4X, TYP



D4436-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

RELEASED
2012-07-23

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO. D4436	REV. A
MFG. APPR.	RF	SHEET 5 OF 7	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	COVER ASSEMBLY	
DATE	12.01.17	NTS	

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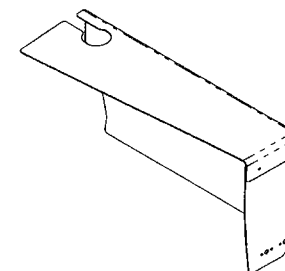
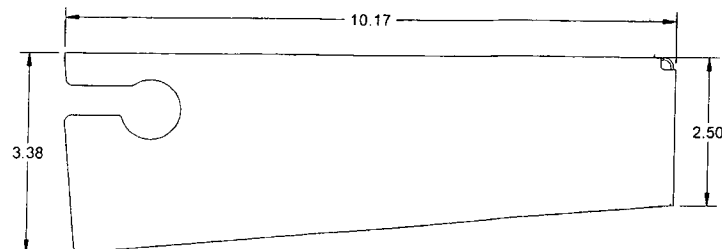
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

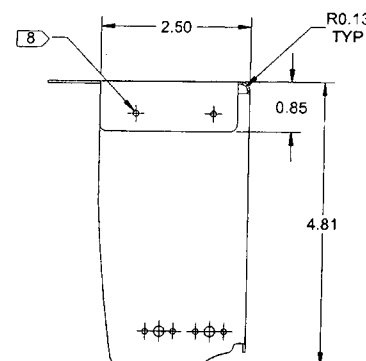
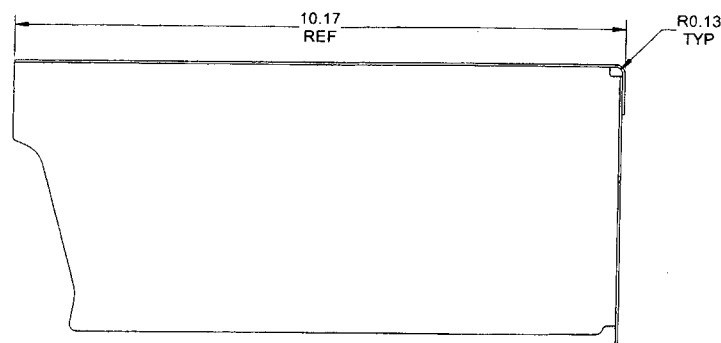
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



80647



D4436-3 BRACKET

NOTES:

- 1) MATERIAL: MAKE FROM D4436-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs
- 8) TRANSFER $\varnothing 0.129$ HOLES THRU 2 PLACES

RELEASED
2012-07-23

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4436	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 6 OF 7	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	COVER ASSEMBLY	
DATE	12.01.17	NTS	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries